



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DEBURRATION

RBIR7028-5
Job Sheet 178597



Rel
7-24

Part No: RBIR7028-5

Job Qty: 6 ea

Part Name: Alignment Seat



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/4/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBIR7### Rev. 0 IPP Rev. A 18.06.04 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Machining-2	gml	JB 18-08-08
110	CNC Lathe	6 pcs	7/9/18	7/9/18	0.00	1.50	MORI SL-154	"	JB 18-08-08
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4	"	JB 18-08-08
130	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC8 Machining-4	"	JB 18-08-08
150	Outsource	6 pcs	7/9/18	7/9/18	0.00	0.00	Outsource12	"	A- 18-08-16
160	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging2	"	"
170	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC6	"	"
180	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-1	"	"
190	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21	"	"

Part Op 110 - 1-Machine as per DWG. FC 255 FOLIO REV: 21 DWG REV: 21 2-Deburr

Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

150 - Issue P/O to GROUPE ALTECH; PO - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

NOT REQD IS MADE FROM SS MEX JULY 26/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.250	MT-4140 QT-R1.250	.4998 ft (.0833 ea)	90-Start up Operation	M126952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.250	0	18	0

Part Specifications

Specifications could not be found.

Plex 7/11/18 10:44 AM dart.logan.david



Container No: S099917



Part: RBIR7028-5

Job No: 178597

Serial No/Batch: S099917

Revision: 0

Inspector:

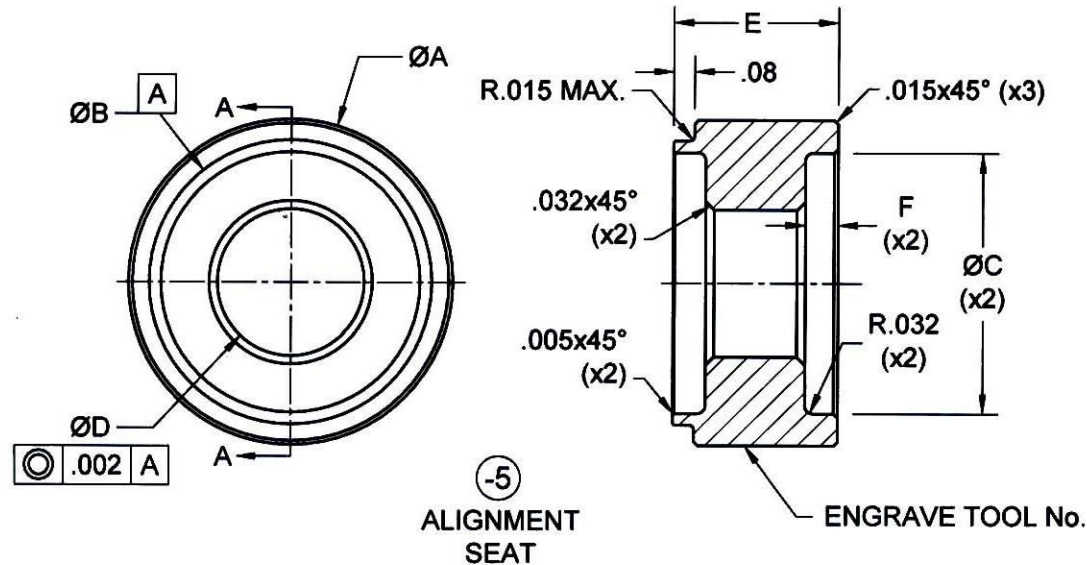
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/08/18

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	-	-	-



TOOL #	BRG. OD.	ØA + .000 - .010	ØB + .001 - .003	ØC + .000 - .010	ØD + .003 - .000	E + .010 - .010	F + .010 - .010	MATERIAL	SPECIFICATIONS
KIR4103-7	.9375	1.188	.929	.798	.313	.804	.270	4140 Q&T	Ø1-1/4 x 7/8

RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; ALIGNMENT SEAT	
DWG NO. CHARTED TOOL No. -5	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS	APPROVED
.XXX ± .005	HEAT TREAT
XX ± .01	FINISH SPEC
X ± .1	BLACK OXIDE
FRACTIONS ± 1/32	USED ON BEARING
ANGLES ± 5°	SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-10 SHEET 4 of 5

M

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBIR7028 Rev. N/A</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																																
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